Work Orde Thursday, July 0							i				Page 1
Revision ID:	D3911-3		A	ccept				S	Setup Star		
	Aft Eyebolt Re 7/1/2010 7/8/2010	Start Qty: 10.00 Req'd Qty: 10.00	·		Cust Item Customer:	ID:	4		Sto		
Approvals:	Process Pla	nn:	Date: <u>/0-7-0/</u>	Tooling: SPC (Y/N):		ate:		I	Run Stai		
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	rision Nbr	•		1					,	
D3911	С				· · · · · · · · ·					1	
100 Bandsaw		Memo	i de de la constante de la con	0.00	10.7.1	. 5	1	10	ø		
Jeaspa Bandsaw	•	Cut blank to	2.885" long 2 2 7 1.75	,					*	# .	
	•		*	0.00	10.7.1	5	*	10	Ø		•
HAAS 1 HAAS CNC vertical	machine #1	Memo 1-MILL as por FOLIO REV	er folio FA917 & dwg ,	0.00 £.	A 10/07	/17	•		,		-

2-Deburr as required

1-MILL as per folio FA917 & dwg , FOLIO REV: _______ DWG REV: ______

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES			1		a
DATE	STEP	PROC	EDURE CH	ANGE	Ву	/	Date	City	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			. •							
Part No	•	PAR #:	Fault Cat	tegory:	NCR: Y	es N	lo DQA	:]	Date:	
	R	esolution:	_ Dispositi	on:	QA: N/0	C Clos	sed:	_	Date: _	
NCR:	- 18-11	We	ORK ORI	DER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng		gn & ate	Verifica Sectio		Approval Chief Eng	Approval QC Inspector
			One: Eng	O'MO' Elig						
·			·							
			·							

Work Order ID	60315
Thursday, July 01, 2010	1:13:42 PM

Page 2

Item ID:

D3911-3

Accept

Date:

Setup Start

Stop



Revision ID:

Item Name:

Aft Eyebolt Receiver

Start Date:

7/1/2010

Start Qty: 10.00

Required Date: 7/8/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date:

Tooling: SPC (Y/N): Date:

Tool ID

Run

Stop

Start

Work Center ID

Sequence ID/

QC:

Operation

Description QC2- Inspect parts off machine FAI/FAIB Set Up/ Run Hours

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

120

QC

Quality Control

Memo

0.00

0.00

130

QC

QC8- Inspect parts - second check

0.00

0.00

MW= 10/07/19

Quality Control

Identify as per dwg & Stock Location:

Memo

140

Packaging Packaging

Memo

0.00 0.00

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES	·			-	₹ .
DATE	STEP	PRO	CEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	_ NCR	:Yes N	io DQ	١:	Date:	
	R	esolution:	Disposition	-	_ QA:	N/C Clos	sed:		Date:	
NCR:				R NON-CONFORM						
DATE	STEP	Description of NC		<u> </u>	ion B		Verific	ation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
										•
		·								
		•						I		
		·						1		

Work Order ID 60315

Thursday, July 01, 2010 1:13:42 PM



Page 3

Item ID:

D3911-3

Accept



Setup Start

Stop



Revision ID:

Item Name:

Aft Eyebolt Receiver

Start Date:

7/1/2010

Start Qty: 10.00 Reg'd Qty: 10.00



Cust Item ID: Customer:

Reference:

A	n	n	r	ก	v	я	ls	•
A	p	p	r	0	V	а	IS	:

Process Plan:

Operation

Description

QC:

Date: Date: _____

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run Start



Required Date: 7/8/2010

Sequence ID/

Work Center ID

150

OC

Memo

QC21- Final Inspection - Work Order Release

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

0.00

Dart Ae	rospace	Ltd						ĺ	
W/O:			W	ORK ORDER CHANGE	S				٠.
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		V	VORK ORD	ER NON-CONFORMAN	NCE (NCI	₹)			
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Sect	ion C	Chief Eng	QC Inspector
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							1		
							1		

Picklist Print

Thursday, July 01, 2010 1:13:47 PM

Work Order ID: 60315

Parent Item:

D3911-3

Parent Item Name: Aft Eyebolt Receiver



Start Date: 7/1/2010

Required Date: 7/8/2010

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP RevA: New issue DD verified by:EC AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	l f	21.9059	0.26	2.736842			
							1						
303 BAR 2" X 1.750"							1		-				
				Location		Loc	Oty	Loc Code					
				MAT		21.	5934		· <u> </u>		ct !	H. A	10/07/17
					115047	21.	5934		2	2.7368	~1	D (I)	10/01/
				MAT53		0.3	1251		_				
* •					113310	0.3	1251						

Dart	Aerospace	Ltd

rospace	Ltd			,			
		WORK ORDER C	HANGES	**************************************			ť
STEP	•	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·					
:	PAR #:	Fault Category:	NCR: Yes	No DQ	4 :	Date: _	
Re	solution:	Disposition:	QA: N/C C	Closed:		Date: _	
		WORK ORDER NON-CONF	ORMANCE (NC	R)			
	STEP	:PAR #:	WORK ORDER C	WORK ORDER CHANGES STEP PROCEDURE CHANGE By :PAR #:Fault Category:NCR: Yes NCR: Yes Resolution:Disposition:QA: N/C Colspan="2">QA: N/C Colspan="2">QA: N/C Colspan="2">QA: N/C Colspan="2">QA: N/C Colspan="2">N/C Colspan	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date By Date PAR #: Fault Category: NCR: Yes No DQA	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr

		WORK ORL	DER NON-CONFORMANC	E (NCK)	!		
	Description of NC	- Middle Control of the Control of t	Corrective Action Section B		Varification	Ammuoval	Annual
TEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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1	EP	Description of NC Section A	Section A Initial	Section A Initial Action Description Chief Eng Chief Eng	Section A Initial Action Description Chief Eng	Section A Initial Action Description Sign & Date Section C	Section A Initial Chief Eng Chief Eng Chief Eng Sign & Date Chief Eng Chief

DART AEROSPACE LTD	Work Order:	40315
Description: Aft Eyebolt Receiver	Part Number:	D3911-3
Inspection Dwg: D3911 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

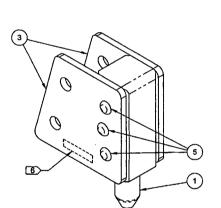
Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Dimension			Inspection	
1.250	+/-0.010	1.250	\			
1.250	+/-0.010	1.256	>			
0.09 X 45°	+/-0.030 X 0.5°	0.092 x45				
1.00	+/-0.030	1.001	>			
0.500	+/-0.010	0.500	\			
R0.13	+/-0.030	RO.125	>			
Ø0.129	+0.005/-0.001	\$0.130	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			
R0.19	+/-0.030	RO.188	>			
0.960	+/-0.010	0.967	\			
0.09 X 45°	+/-0.030 X 0.5°	0.08746	V			
Ø0.257	+0.006/-0.001	Ø0.259				
0.350	+/-0.010	0.352	V		. •	
2.76	+/-0.030	2.765	V			
1.110	+/-0.010	1.110	✓			
0.800	+0.000/-0.010	,799	/			T
0.225	+/-0.010	0.225	/			•
1.80	+/-0.030	1.797	· 🗸			
0.65	+/-0.030	0.649	/			
0.625	+/-0.010	0.625	/			
0.09 X 45°-	+/-0:030 X 0.5°	0.100 1450	~ ~			
Ø0.734	+0.010/-0.000	Ø0.736	/			
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 Measured by:	4.9		Audited by:	ame	Preliminary Approval:	,
Date:	10/07	17	Date:	10/07/19	Date:	

Rev	Date	Change		Revised b	XA.	Approved
Α	10.06.07	New Issue	And.		PL	
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Dart Ae	rospace	e Ltd									
W/O:			AV-14	WO	RK ORDER CHAN	GES			•.		
DATE	STEP		PRO	OCEDURE CHAI	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No			PAR #:								
	R	esolu	tion:	Disposition	:	QA: N	C Clo	sed:		Date:	
NCR:				WORK ORDE	R NON-CONFORM	IANCE (I	ICR)			
DATE	OTED		Description of NC	Corrective Action		Section B		Verification		Approval	Approva
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspecto
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		6	
	D	ESCRIPTION	
	BASKET INSTL	STUD ASSY (LOWE	R)
	AFT EYEBOLT	RECEIVER ASSY	
	BASKET INSTL	STUD (LOWER)	
_	AFT EYEBOLT	RECEIVER	
i	BASKET STUD		
	BASKET PLATE	E-EYEBOLT RECEIVE	R



RIVET



QTY -041

ITEM

2

3

4

QTY -043

P/N

D3911-041

D3911-043

D3911-1

D3911-3

D3911-5 D3911-7

MS20615-4M20

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 0.63 lbs -043: 0.99 ibs

SHOP COPY PATTENTO

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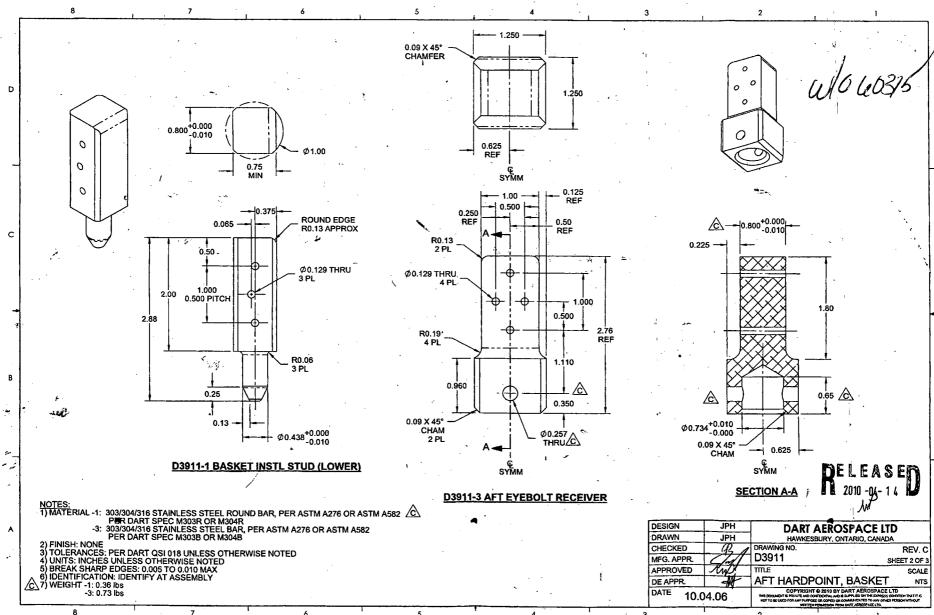
WORK ORDER
NO. 103/5

D3911-043 AFT EYEBOLT RECEIVER ASSY

С	BOM: Q -043 AS D3911-0 ADDED	TY (2): D4087-1 SY. WEIGHT UF 143 & D3911-3 D TO NOTES (SH	JPH	10.04.08		
В			DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16	
Α	NEW ISSUE			JPH	10.03.04	
REV.			DESCRIPTION	TION BY		
DESIGN	1	JPH	DART AEROSPACE LTD			
DRAWN	7	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECK	ED	WO	DRAWING NO.		REV. C	
MFG. A	PPR.	Chil	D3911		SHEET 1 OF 3	
APPRO	VED	MD.	TITLE		SCALE	
DE APPR.			AFT HARDPOINT, BASKET NTS			
DATE 10.04.06			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS FROM THE COMPORTION OF THE DEPTHES CONTROL OF THE THE ROUTE OF THE THE COMPORT OF THE THE ROUTE OF THE THE COMPORT OF THE			

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W/O:			. V	VORK ORDER CHA	ANGES					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Ca	tegory:	NC	R: Yes	No - DQA	\:	Date:	· · · · · · · · · · · · · · · · · · ·
		esolution:							Date:	· • • • • • • • • • • • • • • • • • • •
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	E (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descript Chief Eng	Section B tion	Sign Date			Approval Chief Eng	Approval QC Inspector
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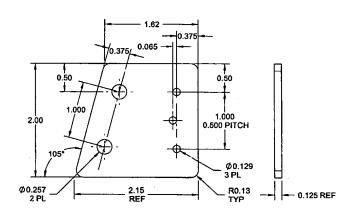
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			=						
						<u> </u>			

Part No:	PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)		WORK ORDER NON-CONFORMANCE (NCR)				
		Description of NC	Corrective Action Section B			Verification	Approval	Annroyal
DATE	ATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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0 0 0



D3911-5 BASKET STUD PLATE

NOTES: 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 PER DART SPEC M304S11GA OR M303S11GA

- PER DART SPEC M304S11GA OR M303S11GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 7) WEIGHT -5: 0.13 lbs
 -7: 0.13 lbs

wlo 403/5 Ø0.129 4 PL R0.13 1.000 1.99 1.000 0.500 0.454 0.450 0.150 Ø0.257 2 PL 75° **-** 0.250 0.250 0.125 REF -0.500 1.100

D3911-7 BASKET PLATE-EYEBOLT RECEIVER

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	W.	DRAWING NO. REV. (
MFG. APPR.	11	D3911 SHEET 3 OF
APPROVED	INF.	TITLE SCALE
DE APPR.	-##-	AFT HARDPOINT, BASKET NTS
DATE 10.0	04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT BY PRIVATE AND CONFERENCE, MAD BE PUBLISHED ON THE DOTRIBUS CONDITION THAT IT IS NOT TO BE USED FOR ANY TEMPORE ON CONDITION OF CONDITION TO MAY OF THE PRIBLEM WITHOUT

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						,			
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Part No:	PAR #:	_ Fault Category:		NCR: Yes No DQA: _	Date:	
Resolution:	•	Disposition:	•	QA: N/C Closed:	Date:	

NC	CR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Description of NC		Corrective Action Section B				A	
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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